

# Work Order ID 57970

April 21, 2010 9:24:26 AM



Page 1

Item ID: D4038-6

Revision ID:

Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4038

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 2.19" LONG

0.00

*gmf 10/04/24*

*4 0*

105

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA883

DWG REV: B

FOLIO REV: AA

DEBURR

0.00

*gmf 10/04/25*

*4 2*

*PTD*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D4038-6 PAR #: N/A Fault Category: MACHINE NCR: (Yes) No DQA: AD Date: 10.05.03  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AD Date: 10/05/03

| NCR: 57970 |      | WORK ORDER NON-CONFORMANCE (NCR)                                  |                             |  |                        |                           |                       |                          |
|------------|------|---|-----------------------------|--|------------------------|---------------------------|-----------------------|--------------------------|
| DATE       | STEP | Description of NC<br>Section A                                    | Corrective Action Section B |  |                        | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|            |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng                    | Sign &<br>Date         |                           |                       |                          |
| 10/04/25   | 105  | 1 part scrap. the drill<br>broke inside the part.<br>R.C. process | <u>AD</u><br>ASPL12         | destroy and replace<br>Qty 2 Batch: <u>M110167</u> | <u>and</u><br>10/04/25 | K.A<br>10/04/26           | <u>AD</u><br>ASPL12   | <u>AD</u><br>10-04-26    |
|            |      |   |                             |  |                        |                           |                       |                          |
|            |      |   |                             |  |                        |                           |                       |                          |

NOTE: Date & initial all entries

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Item ID: D4038-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

amt 10/04/25

4

2

B.A 10/04/26

4

0

del 10/04/27

4

0

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Item ID: D4038-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(4)

BR 10-4-27

160

Identify as per dwg & Stock Location: 1/0

0.00



Packaging

Memo

0.00

Packaging

10/04/27 (4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/2007  
BR 10-4-27  
(4)

# Picklist Print

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Page 1

Work Order ID: 57970

Parent Item: D4038-6

Parent Item Name: Block

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6B1.500X02.00<br>0        |                        | Purchased     | No          |                     |                  |                 | f                  | 9.5000         | 0.6989                   |               |                |        |



6061-T6 Bar 1.50 x 2.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT10

9.5

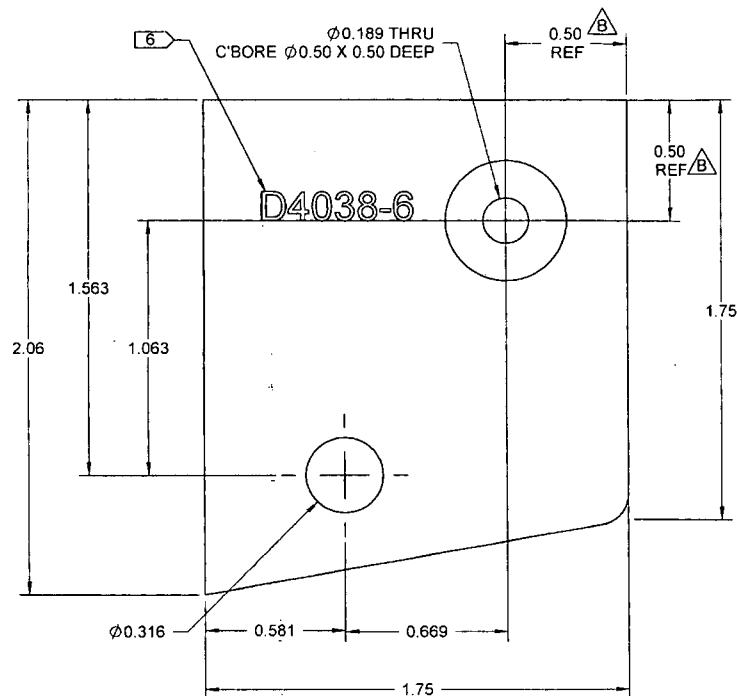
110167

9.5

0.6989 mR 10/04/24

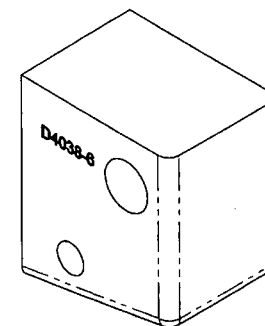


w/o 57970



R0.13  
TYP

**D4038-6 BLOCK**



RELEASED  
2010-04-14  
MD

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH  
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.40 lbs

|            |          |  |               |
|------------|----------|--|---------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>  |               |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |               |
| CHECKED    |          | DRAWING NO.  | REV. B        |
| MFG. APPR. |          | D4038  | SHEET 8 OF 14 |
| APPROVED   |          | TITLE  | SCALE         |
| DE APPR.   |          | BRACKET  | NTS           |
| DATE       | 10.01.05 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> |               |